

What is claimed is:

1, An insert molding method for injection molding of resin or rubber at an insert set in a lower mold by injecting and filling melted resin or rubber into a cavity of an upper mold through a gate in a state where said upper mold and lower mold are disposed so as to be opposed to each other, wherein a movable supporting member having flexibility, on which said insert is placed, is vertically movably disposed in a recess formed on said upper surface of said lower mold, and the underside thereof is supported by the tip ends of shafts of a plurality of pressing means that independently operate, and said movable supporting member is moved while being pressed by said respective shafts of said pressing means to said upper mold at a plurality of positions, and molding is carried out in a state where the upper surface of said insert is uniformly brought into contact with the underside of said upper mold by bending deformation of said movable supporting member.

2, The insert molding method as set forth in Claim 1, wherein said movable supporting member for setting an insert has flexibility at least between shafts of a plurality of pressing means.

3, A metal mold being utilized in an insert molding method for injection molding of resin or rubber at an insert set in a lower mold by injecting and filling melted resin or rubber into a cavity of an upper mold through a gate in a state where said upper mold and lower mold are disposed so as to be opposed to each other, a movable supporting member having flexibility, on which said insert

